

# Work Order ID 69975

Wednesday, May 25, 2011 9:06:17 AM



Page 1

Item ID: D3953-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Spring Spacer

Start Date: 5/25/2011 Start Qty: 30.00



Cust Item ID:

Required Date: 6/2/2011 Req'd Qty: 30.00



Customer:

Reference:

Approvals:

Process Plan:

*[Signature]*

Date: 11-05-25

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3953

C

100

0.00



Hardinge

Hardinge CNC Lathe Small

Memo

0.00

TURN AS PER FOLIO FA854 & DWG

FOLIO REV: *1/1*

DWG REV: *C*

DEBURR

*DA 11/6/6*

*33*  
*54*

*[Signature]*

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

*DA 11/6/6*

*33*  
*54*

*[Signature]*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 69975**

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Page 2

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Item Name: Spring Spacer

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Required Date: 6/2/2011 Req'd Qty: 30.00



Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC8- Inspect parts - second check

0.00

B.A 11/06/06

33

0



QC

Memo

0.00

Quality Control

130

Identify as per dwg &amp; Stock Location: 96

0.00



Packaging

Memo

0.00

Packaging

11/6/06 SP (33x)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/07 JF  
CMF  
11-06-06

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# Picklist Print

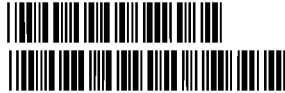
Wednesday, May 25, 2011 9:06:24 AM

Page 1

Work Order ID: 69975

Parent Item: D3953-7

Parent Item Name: Spring Spacer



Start Date: 5/25/2011

Required Date: 6/2/2011

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP RevA: New issue DD verified by:EC  
revC DD 10.03.02 verified by:EC

IPP Rev:B as per dwg

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MDELNRINR0.750

Purchased

No

100

f

73.2000

0.05

1.578947



Delrin Round Bar 0.75"

125616

Location

Loc Qty

Loc Code

MAT055

73.2

115472

7.5

116183

3.6

117273

56

117322

6.1

1.5 RT

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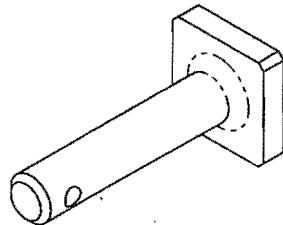
**NOTE:** Date & initial all entries



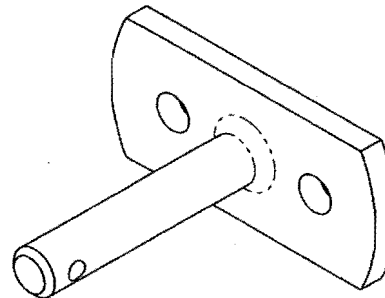
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 69925 11-05-25



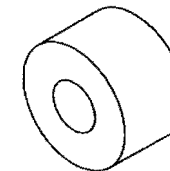
**D3953-1 GAS SPRING BRACKET**  
(FULL LID)



**D3953-3 GAS SPRING STUD, LID**



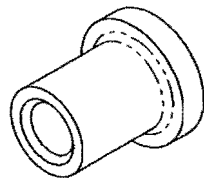
**D3953-5 GAS SPRING STUD, BASE**



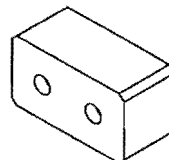
**D3953-7 GAS SPRING SPACER**



**D3953-9 GAS SPRING WASHER**



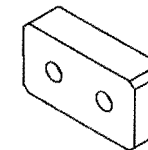
**D3953-11 GAS SPRING SPACER**



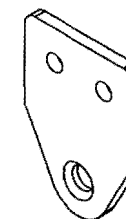
**D3953-13 GAS SPRING SPACER**  
(FULL LID)



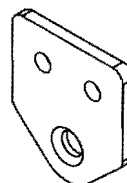
**D3953-15 GAS SPRING BRACKET**  
(SPLIT LID)



**D3953-17 GAS SPRING SPACER**  
(SPLIT LID)



**D3953-19 GAS SPRING BRACKET**  
(SQUARE BASKET)



**D3953-21 GAS SPRING BRACKET**  
(SQUARE BASKET)

RELEASED  
2010-07-26

C	PARTS -19 & -21 ADDED (SHT 1 & 4); CSK CALLOUT WAS CHAM (C6-2, B6-3, C6-4); & SYMM WAS C SYM ABOUT (C7-2, C7-4); SECTION C-C REPOSITIONED TO B24 REASON: ADD. PARTS REQ'D; DRAFTING ERRORS	JPH	10.01.29
B	SHEET 3 ZONE C1, DIM 0.05 MIN WAS 0.13, MULTIPLE DIMENSIONS MIN/MAX REMOVED TOLERANCE ADDED. REASON: DIFFICULTY INSTALLING COTTER PIN AT NEXT ASSY.	AJS	09.11.11
A	NEW ISSUE	AJS	09.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	<b>D3953</b>	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>GAS SPRING LID COMPONENTS</b>	NTS
DATE	10.01.29	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

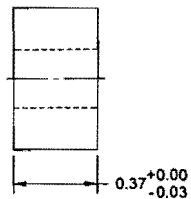
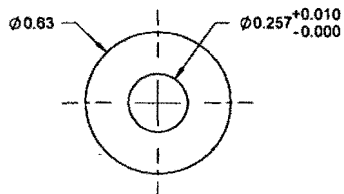
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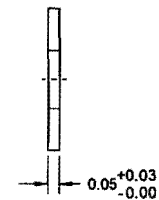
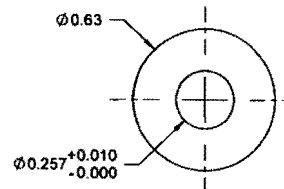
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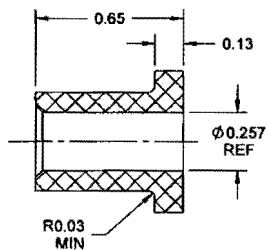
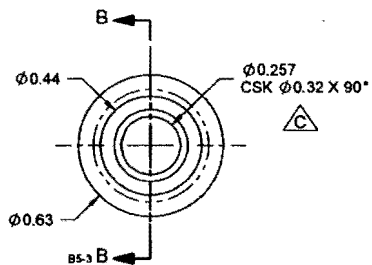
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**D3953-7 GAS SPRING SPACER**

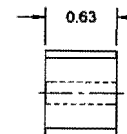
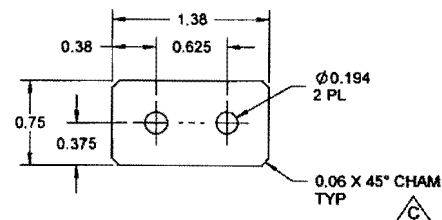


**D3953-9 GAS SPRING WASHER**



**D3953-11 GAS SPRING SPACER**

**SECTION B-B 87-3**



**D3953-13 GAS SPRING SPACER**

**NOTES:**

1) MATERIAL -7,-9 & -11: DELRIN II 150E OR ACETRON GP ACETAL, BLACK  
REF DART SPEC M-DELRIN-R

-13: AISI 304 STAINLESS STEEL BAR  
REF DART SPEC M304B

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 016 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION -13 ONLY: IDENTIFY WITH DART P/N "D3953-13" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT -7/-9/-11: < 0.01 lbs EACH

-13: 0.17 lbs

**RELEASED**  
2010-02-26

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3953	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	GAS SPRING LID COMPONENTS	NTS
DATE	10.01.29	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

**Dart Aerospace Ltd**

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